

Work Order ID 60182

Monday, June 28, 2010 1:31:37 PM

Page 1

Item ID: D3826-041

Accept

Revision ID:

Item Name: Rib / Gusset Assembly

Start Date: 6/28/2010 Start Qty: 6.00

Required Date: 7/2/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3826

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- use DT9434 to assemble D2325 support gusset together
2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod
Batch: 111679

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

10.07.01

10.07.01

10.07.01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60182

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Monday, June 28, 2010 1:31:37 PM

Item ID: D3826-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib / Gusset Assembly

Start Date: 6/28/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: Basket

0.00



Packaging

Memo

0.00

Packaging

⑥ PD 10.07.01

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/01
MF
10.7-01

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Picklist Print

Monday, June 28, 2010 1:31:43 PM

Page 1

Work Order ID: 60182

Parent Item: D3826-041

Parent Item Name: Rib / Gusset Assembly



Start Date: 6/28/2010

Required Date: 7/2/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2235-1 Basket Rib		Manufactured	No				Each	4.0000	1	6			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			4						
					59267		4						
D3929-041 Gusset Assembly		Manufactured	No				Each	5.0000	1	6			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			5						
					57955		2						
					59070		3						
D3929-042 Gusset Assembly		Manufactured	No				Each	6.0000	1	6			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			6						
					59928		6						

Cpl 10.06.30
B59925 → ②

Cpl 10.06.30
B59927 → ① *
② ③

Cpl 10.06.30

⑥

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

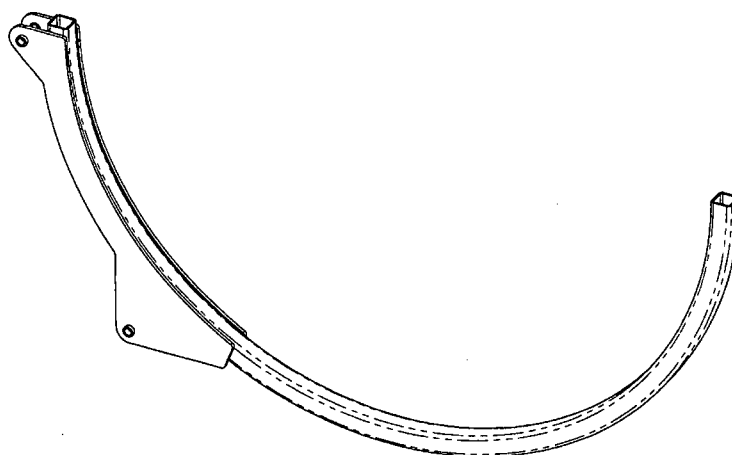
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY



D3826-041 RIB/GUSSET ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60182

PS 10-6-28

RELEASED
8/10/12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.32 lbs

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.08.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.04.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3826** REV. B
SHEET 1 OF 2
TITLE **RIB/GUSSET ASSY** SCALE NTS

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△ D3929-042
GUSSET ASSEMBLY

△ D3929-041
GUSSET ASSEMBLY

TYP

0.250

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

W/O 6018

RELEASED
9/24/2016

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3826	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB/GUSSET ASSY	NTS
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